00064

Dart Aerospace Ltd.

Date: Tuesday, 2/27/2007 12:59:03 PM
User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: ADAPTER
Job Number	: 30975		
Estimate Number	: 12752		
P.O. Number	: N/A	**Part Number**	: D35737
This Issue	: 2/27/2007 **S.O. No.** : N/A	**Drawing Number**	: UNDER REVIEW
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: U/R
Previous Run	: N/A	**Material**	: N/A
Written By	:	**Due Date**	: 3/6/2007 **Qty:** 3 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-01-29 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X02500	6061-T6 Bar .50" x 2.5"	
	Comment: Qty.: 0.3066 f(s)/Unit Total : 0.9198 f(s) 6061-T6 Bar .50" x 2.5" Batch: M10345	gnl 07/02/28	3
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW 3.50 Cut blank ~~3.250~~" long	gnl 07/02/28	3
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA677 and Dwg D3573	J.F/ MS 07/02/28	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F/ MS 07/02/28	
5.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK	ENGINEERING APPROVAL UG 07.03.27 SA 07.03.01	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	PL 07/03/01	

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Job Number: 30975 **Part Number:** D35737

Job Number:

Seq. #:	Machine Or Operation:	Description :
7.0	POWDER COATING	POWDER COATING

M101601 (3x)

Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 M-L 07/03/02

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

ENGINEERING APPROVAL

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION SAD 07/03/02 (3)

9.0	PACKAGING 1	PACKAGING RESOURCE #1

FOR ENGINEERING USE ONLY

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____ 7/3/05 (3) Jess Cook

10.0	QC21	FINAL INSPECTION/W/O RELEASE

proj. 000604 (3)

Comment: FINAL INSPECTION/W/O RELEASE 07/03/05

Job Completion

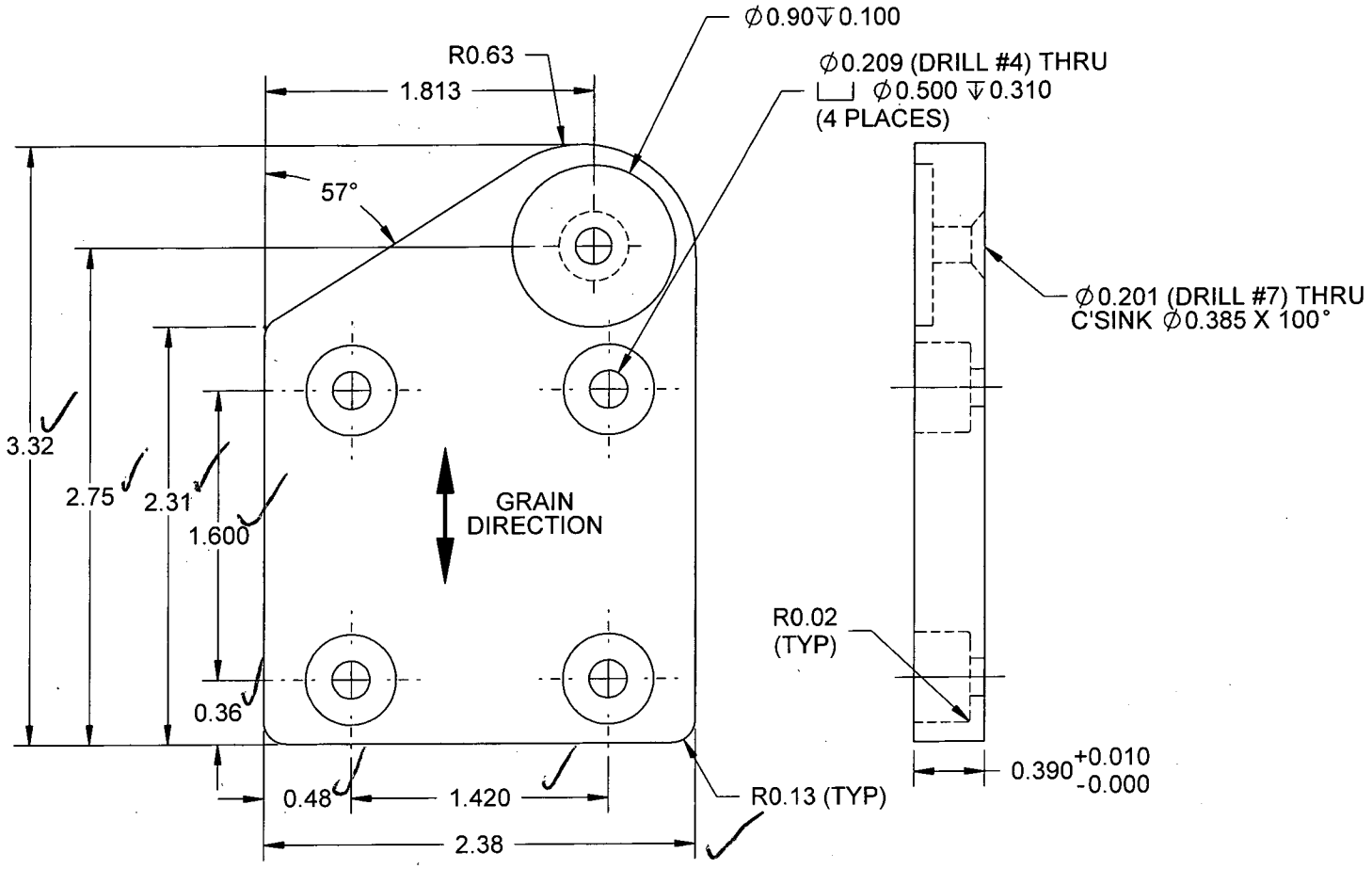
07.03.05

Form: rprocess

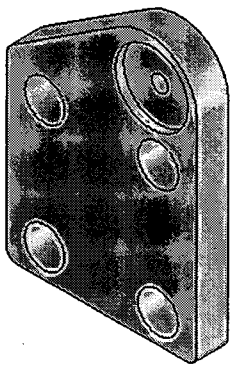
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

UNDER REVIEW
07-02-19 LE



D3573-7 ADAPTER (SHOWN)
(D3573-9 ADAPTER (OPPOSITE)



NOTES:
1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3573-7/-9" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

DART AEROSPACE LTD	Work Order:	30975
Description: Adapter	Part Number:	D3573-7
Inspection Dwg: D3573 , Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[x] First Article [x] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R.63	±.030"	.63	✓			
1.813	±.010"	1.815"	✓			
57°		57°	✓			
3.32	±.030"	3.32	✓			
2.75	±.030"	2.75	✓			
2.31	±.030"	2.31	✓			
1.600	±.010"	1.600	✓			
.36	±.030"	.36	✓			
.48	±.030"	.48	✓			
1.420	±.010"	1.420	✓			
2.38	±.030"	2.377	✓			
R.13	±.030"	.13	✓			
R.02	±.030"	.02	✓			
.390	+.010" -.000"	.395"	✓			
Ø.201	+.005" -.001"	.202	✓			
Ø.385 x 100°	±.010"					
Ø.209	+.005" -.001"	.210	✓			
Ø.90	±.030"	Ø.892	✓			
.100	±.010"	.100"	✓			
.500"	±.010"	.495"	✓			

Measured by:	MS/J.F.
Date:	07/02/28

Audited by:	[signature]
Date:	07/03/01

Prototype Approval:	LE
Date:	07.03.21

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	